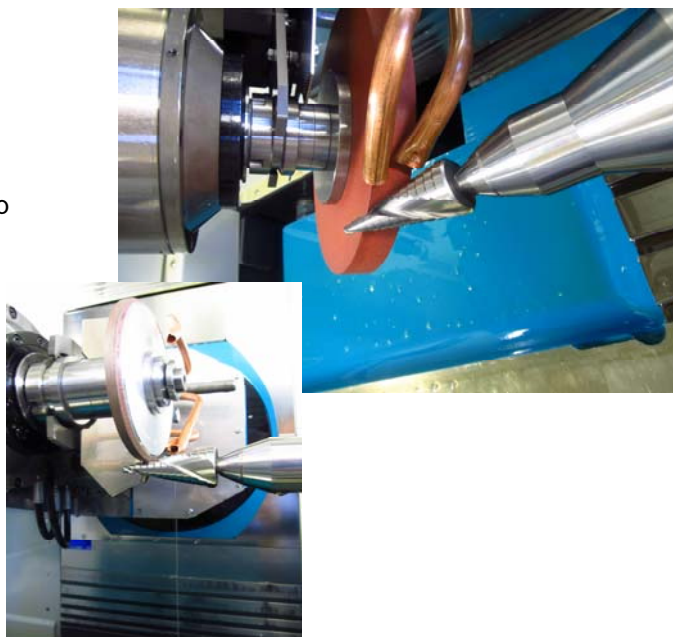


Sheet Metal Stepdrill Ø6 - Ø30

A06-200

The spiral flute of the sheet metal stepdrill is ground in 4 passes of each 0.6 mm increment plus 2 additional fast sparkout passes. The vitrified wheel for fluting has to be dressed after each 5 pieces. The O.D. is ground step by step in one pass (overmeasure around 0.1 to 0.3 mm)



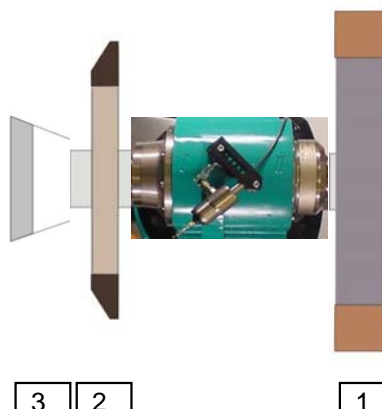
1. Cycletime for Production

Workpiece: Ø 6 - 30 mm, Z 2, Length 70 mm, Helix angle 25° Material HSS								
Operations								
Feed [mm/Min]	2000	900	100	70	100	350	150	9000
Power [kW]		8	2	1	1	2	2	1
Cutting speed [m/s]		48	32	32	32	32	32	
Used wheels								
Grinding time [s]	8	215	28	32	28	166	41	16
Total cycle time	8 Min 54							

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø200 B20 C120
2	1V1 Ø150 B106 V45°
3	11V9 Ø100 B126



3. Machine and Software Requirements

Machines:	5 axes CNC grinders : GEMINI DMR	Coolant:	Synthetic Oil, pressure 16 bar
Control:	Fanuc 31i	Software:	Quinto 5
Accessories:	Dressing		
Responsible engineer:	OP. 2.4.12		

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